Work Order ID 92644 November-06-12 12:26:43 PM				*92					Page 1			
Item ID: D	350-567-113			Accept	*N90	0040	100)*	Setup	Start	1.7	S1*
Item Name: R		extra Large ety: 3.00 \Qty: 3.00	*3* *3*		Cust Ite Custom					Stop		S2*
1	Process Plan:M QC:		Date: \\2-\\-07	Tooling: SPC (Y/N):		Date:			Run	Start Stop	171	R1* R2*
Sequence ID/ Work Center ID	Operati Descrip			Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accep Qty	ot Re Qt	ject y	Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	r										
IIN-D350-567	Rev D		1 B							N	165	17-12-19
*100 *100* DC Document Control	DOCUM	ENT CONTROI Memo Photocopy bl	uefile & type labels per Pl	0.00	12 19 CHG003							lallal SAS
*110 *110* Packaging Packaging	Packagin	Memo Pick Packing	Kit DT 8439 TEMPLATE IS	0.00 0.00 INCLUDED***								12/12/19/
120 *120* QC Quality Control	QC4-100	0% Inspect kits t	or completeness	0.00 Sn	A 219						(-

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Skid-tube Crosstube Engineering Rework Water Jet Quality Part No. Scrap Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Work Order Update Large Fab Composite Supplier NCR No. Description of work order update Initial Action Sign & Root Chief Eng Qty Date Verification QC Inspector Cause Date Step or Non-conformance Description Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Centre Not Concentric to O/S Over/Under tolerance Temperature/Cure Hardware Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Maintenance Contamination Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing **Out of Calibration**

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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Page 2 November-06-12 12:26:43 PM Accept Setup Start D350-567-113 *N900040100* Item ID: **Revision ID:** Replacement Window, Extra Large Item Name: 11/06/12 Start Qty: 3.00 **Start Date: Cust Item ID:** Required Date: 11/16/12 Req'd Qty: 3.00 **Customer:** Reference: Run Start Process Plan: _____ Date: ____ Tooling: Date: Approvals: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Operation Code Qty Qty Number Stamp Work Center ID **Description Run Hours** 0.00 130 My (3/15/14 Packaging *130* 0.00 Packaging Identify and pack for shipping as per PPPD350-567-113 Packaging Location: PPP Rev: 0.00 140 QC21- Final Inspection - Work Order Release ML5 12-12-19
MF *140* 0.00 QC Memo Quality Control

				DQA:	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

									QA Closed:	Date:	
Work Orde	r:				DISPOSITION		• 4	AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is Work Order Update	1 1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other				1.7							
Process											
Supplier											
Training											
Unapproved											
					F.	AULT CATE	GORY				
Landir	ng Gear				General					_	_
	Bending				Bend	Grain		<u>. </u>	Ovalized		Pressure/Forced
	· Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
<u> </u>	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instruc	tions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance	1	Part Moved		
	Heat Trea	at			Countersink	Mislab	eled		Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Offset					
	Torque V	Vaves in E	xtrusio	n	Drawing	Out of	Calibration				
	Turning S	equence			Finish	Out of	Sequence				
	Wave/Tw	vist in Tul	oe		Folio	Outsid	e Dimensions				18X

217.0000	12	36	JB	
: Code				
	122	452		
639.0000	12	36		
<u>Code</u>				
				140
	123	1973		
695.0000	12	36	" ₂ 5	12/12/19
c Code			V	, , , ,

Page 1

Status

Required Date: 11/16/12

Date

Issued

Required Qty: 3.00

Qty

Issued

Start Date: 11/06/12

Qty per Kit Total

Qty

Start Qty: 3.00

4

32

86

200

300

695

9

80

127 179

300

Each

Loc Code

110

Loc Qty

120077

121287

122441

122973

123150

121524

122317

122452

122973

123150

No

Location

ST365

Purchased

2600/LW

Gamloc Retaining Washer

			DQA:	Date:	, , , , , , , , , , , , , , , , , , ,
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date:	
Work Orde	∍r:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	az ak
	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	T is	nitial	Ad	tion	Sign &		1.50
Cause		Date	Step	Qty	1	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator						v					-		
Material			}										
Setup													
Other													
Process									ļ			Ē	4
Supplier													
Training													
Unapproved													*
						F	AUL	T CATE	GORY				\$100
Landi	ng (Gear				General					-		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	\vdash	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.		_	Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	-	Cuffs				Contamination	Ш	Mainte	enance		Part Moved		
		Heat Trea				Countersink	Ш	Mislabe	eled		Positioned \	Vrong	-
:	\rightarrow	Inspection	•	Tube		Cut Too Short	\vdash	Misread	d ·		Power Loss/	Surge	Other
		Ripples in				Drill Holes	\vdash	Offset					
		Torque W			n	Drawing	\vdash		Calibration			<u> </u>	
	Turning Sequence				Finish	Ш	Out of :	Sequence					
		Wave/Tw	ist in Tub	e		Folio		Outside	Dimensions				40

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November-06-12 12:26:43 PM

Work Order ID:

92644

Parent Item:

D350-567-113

Parent Item Name:

Replacement Window, Extra Large

AN526G832R9 Screw

Purchased

Purchased

Manufactured

No

Start Date: 11/06/12

Required Date: 11/16/12

Start Qty: 3.00

Required Qty: 3.00

NAS1149DN832J

No

No

ST345 122814 123522 ST346 120181 121556

ST347 118983

72232

79478

83542

90297

Location ST403

Location

110 Each

110

Loc Qty

741.29207 15.38

0.43737

225.4747

110

500

3

Loc Qty

1747.5

1747.5

sf

Each

110

Loc Qty

668 368

300

25

21

Each

0.0000

741.2921

Loc Code

702.0000

Loc Code

90297

D3290-041

Replacement Window Assembly

Manufactured

Purchased

Location ST219

No

Loc Oty .3

89112 110 1,747.5000

Loc Code

3.0000

EG-778150-550-ROL

Location ST416

123239

Loc Code

23239

DQA:	Date:	2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

ii.			·	<u>. </u>		_	•		QA Closed:	Date	
Work Orde	ır.				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part N		,			Rework Scrap	4 1	Skid-tube Machining	Crosstube Small Fab		Water Jet	Engineering Quality
NCR N	lo				Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descr	iption of work order update	Initial	Ac	tion	Sign &		
Cause	Date Step Qty			or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
· . •					F	AULT CATI	GORY				
	ng Gear				General				_		
* >	Bending Centre-N Cracks Crushed/ Cuffs Heat Tree	'Crimped		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink	Instruc	tion Incomplete tions Incomplete, enance	/Unclear	Ovalized Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
}	Inspectio		Tube	-	Cut Too Short	Misrea		<u> </u>	Power Loss/		Other
ł	Ripples in	-	Tube	-	Drill Holes	Offset		L	Ti owei rossi	Juige _	Jouren
ŀ	Torque V		extrusio	_n ⊢	Drawing	\vdash	Calibration				
ŀ	Turning S			" 	Finish	\vdash	Sequence				
t	Wave/Tw				Folio		e Dimensions				

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Picklist Print

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November-06-12 12:26:43 PM

Work Order ID:

92644

Parent Item:

D350-567-113

Parent Item Name:

Replacement Window, Extra Large

MS20426AD3-5

Purchased

Purchased

No

110

479

Each

Start Date: 11/06/12

Start Qty: 3.00

Required Date: 11/16/12

Required Qty: 3.00

Location ST316 4179 4444 4533 No

122141

Loc Qty 11508 390 5022 6096 110 Each

11,508.000

4444

MS21042L08 Nut

Rivet

Location Loc Qty 315 122452 9 500 ST315 122814 500 ST317 479

Loc Code

Loc Code

22/4

	A A	DQA:	Date:	?
ICR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date:	
Work Orde	er:	-4				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	10 J
Part N	-	•				Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
raiti	٠٠. ـ					l ———			noforming	Finishing		e/Packaging	Other
NCR N	u o					Use-as-is Work Order Update		mem	Large Fab	Composite		Supplier	- Other
NCK	٠٠٠					Work Order opdate	<u>'</u>		Large rab	Composite		Supplie!	J
Root					Descri	ption of work order update	lı	nitial	Ac	tion	Sign &		4.
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling													
Operator												9	
Material							l						
Setup													
Other													
Process	Ш					•	1						
Supplier	Ш						ł						*
Training													
Unapproved							<u> </u>					ŧ	
						F	AUL	T CATE	GORY			- I	,
Landi	ng G	iear				General					,		_
	Ш	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Ш	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance *		Part Moved		
		Heat Trea	it			Countersink		Mislabe	eled		Positioned V	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					- 8
		Torque W	aves in E	xtrusio	n 「	Drawing		Out of	Calibration				
		Turning S	equence			Finish		Out of	Sequence				
		Wave/Tw	ist in Tub	e		Folio		Outside	Dimensions				

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PARTS LIST 5.0

Qty	Qty	Qty	Qty	Qty	Qty		
-015	-017	-025	-027	-111	-117	Part Number	Description
X		97				D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	Х					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
— —				Х		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					Х	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
 		1	1		<u> </u>	D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
<u> </u>	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

	<u> </u>		<u> </u>	٥.		
Qty	Qty	(Qty-)	Qty	Qty	Daniel Mirrordona	Description
-013	-023	G113/	-115	-031	Part Number	Description Control of the Control o
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		Х			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			Х		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT
						(SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
<u>'</u>	1				D2942	REPLACEMENT WINDOW, LARGE
	· · · · · · ·	€ 1==			-D3290-041	-REPLACEMENT WINDOW ASSEMBLY-EXTRA LARGE
					-00200-04-1	at the following the second of
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		[1			D2463-0860	*NEOPRENE SEAL /
	9	6 12==			-2600-6	-1/4-TURN FASTENER
dr.	9	£125		- Philippe and Philippe	2600-LW	-WASHER
	9	12	3.35	~c -∞c -5	212-12	7RECEPTACLE
	22	[21]	Til .		AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	L 42			AN960JD8	WASHER
	22	(21	************		MS21042L08	_NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ.	2 SQ.	12 SQ.			.N/A	-9:70z-7781-S-GLASS-UNIVERSAL WEAVE
YD	YD	YD				
					D2463-0450	NEOPRENE SEAL
				1		DOUBLER
				1	D3210-1	
		ļ		1	D3211-1	BRACKET FLOOR WINDOW
		<u> </u>		1	D3212-1	DOOR ASSEMBLY
				1	D3213-041	
			1		D3293-1	DOUBLER
		ļ	1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
		ļ	1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
	ļ	ļ	9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET

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Revision: **D**

Date: 08.07.08